

Work Order ID 70036

Wednesday, May 25, 2011 1:03:13 PM



Page 1

Item ID: D3372-7

Accept



Setup Start



Revision ID:

Item Name: Slider Body

Stop



Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/05/25 Tooling: Date:

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3372	Rev B

100



BAND SAW

Bandsaw

Jeaspa Bandsaw

0.00

on 11/05/07

4 0

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

0.00

B.A 11/07/14

4 0

120



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

B.A 11/07/14

4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.-
Stamp

130

QC8- Inspect parts - second check

0.00

amk 11/07/15

4 x



QC

Memo

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

4 x bl 11-7-18.



HandFinish

Memo

Hand Finishing

150

QC3- Inspect Part Finish

0.00

4 x bl 11-7-18



QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Slider Body

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Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

160



Small Fab

Operation
Description

Small Fab

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5/10/08

CY

180



Powdercoat

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00

4/10/01

0.00

4 BL 11-7-18

Powder Coating

START TIME: 2:15. OVEN TEMPERATURE:
320° FINISH TIME: 3:15.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70036

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Item ID: D3372-7

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Setup

Start



Revision ID:

Item Name: Slider Body

Stop



Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Run

Start



Stop


**Sequence ID/
Work Center ID**
190


QC

Quality Control

**Operation
Description**
QC3- Inspect Part Finish
Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



Packaging

Packaging

Identify as per dwg & Stock Location: CA

0.00

SB 11/10/12

(4)

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

N 11/10/13 (4)

MF
11-10-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 1:03:11 PM

Page 1

Work Order ID: 70036



Parent Item: D3372-7



Parent Item Name: Slider Body

Start Date: 5/25/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A□05.01.18□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN6-36A 		Purchased	No			110	Each	77.0000	1	4		<i>SA 1107/10</i>	

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST343	77	
117441	77	

M6061T6B1.500X01.25
0

Purchased

No

160 f 11.3278 0.3833 1.613895

6061-T6 Bar 1.50 x 1.25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT004	11.3278	
107461	0.9	
110936	10.4278	

1102 and 1107/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

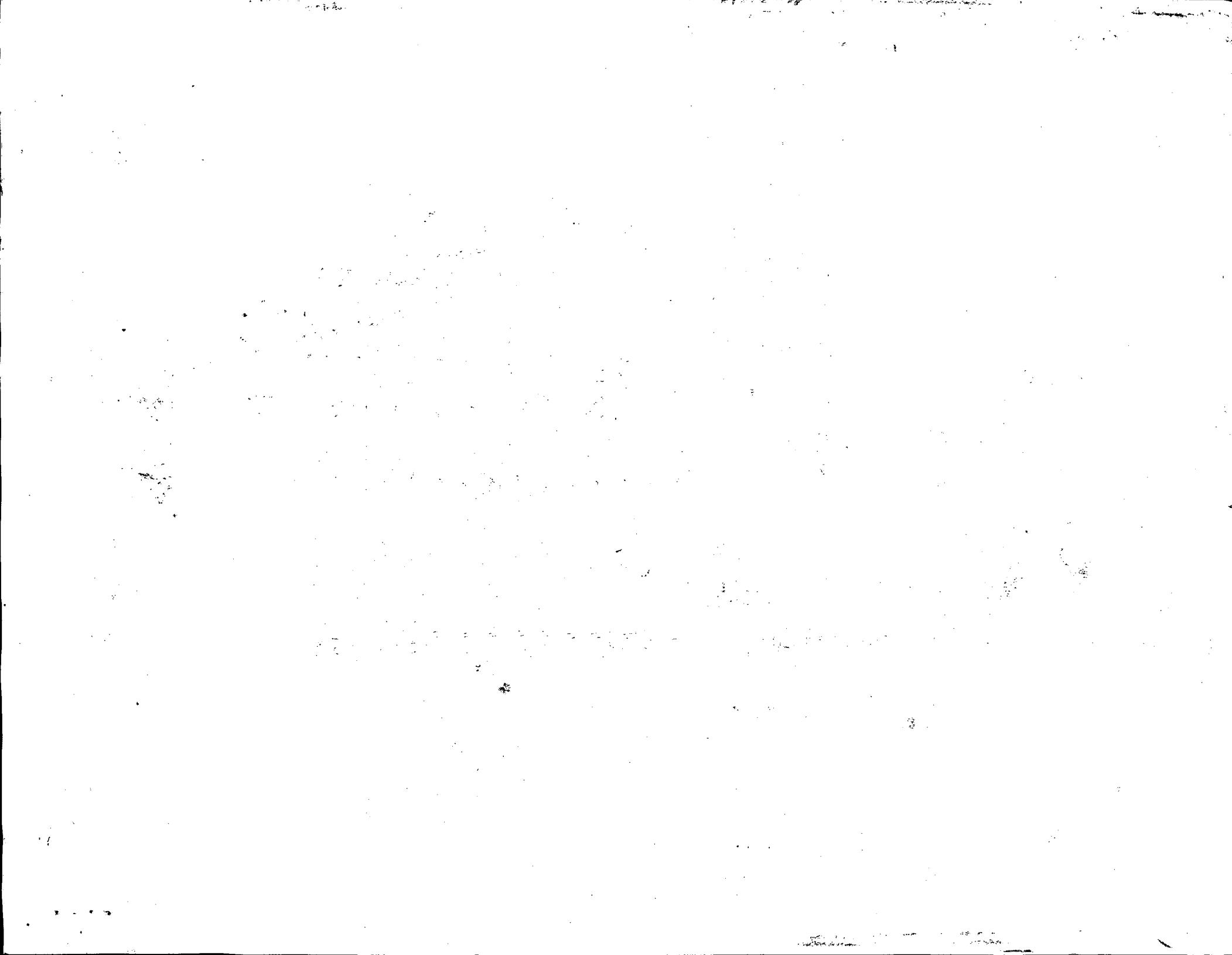
DART AEROSPACE LTD	Work Order:	70036
Description: Slider Body	Part Number:	D3372-7
Inspection Dwg: D3372	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>B.A</u>	Audited by:	<u>Amf</u>	Prototype Approval:	N/A
Date:	11/07/14	Date:	11/07/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	09.05.04	Dimensions revised	KJ/DD	



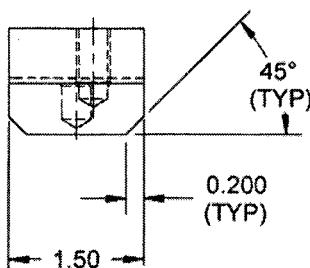
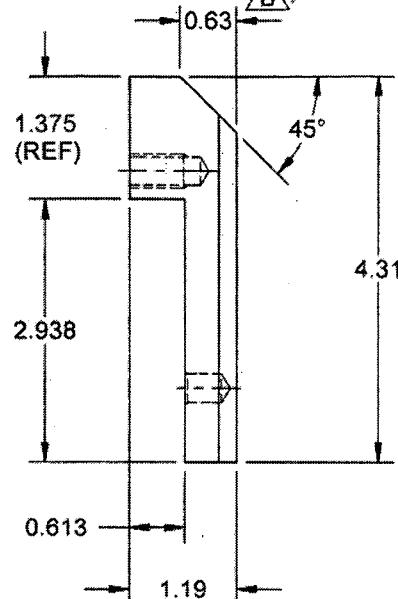
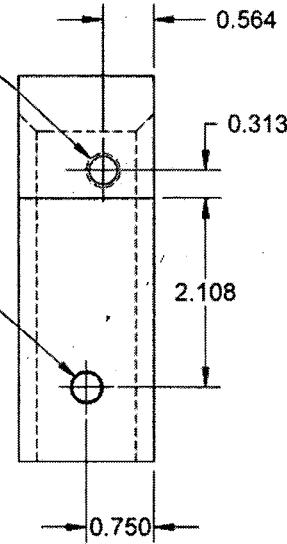


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	D3372	REV. B SHEET 7 OF 8
DATE	05.02.23	TITLE	COLLECTIVE LOCK	SCALE 1:2

RELEASED
05/04/23
(B)

DRILL Ø0.332
("Q" DRILL) x 0.881 DEEP.
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL Ø0.323
("P" DRILL) x 0.500 DEEP
CHAMFER 0.030 x 30°



05/11/2023

W10.70034

D3372-7 SLIDER BODY

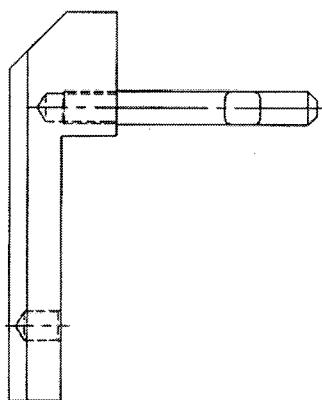
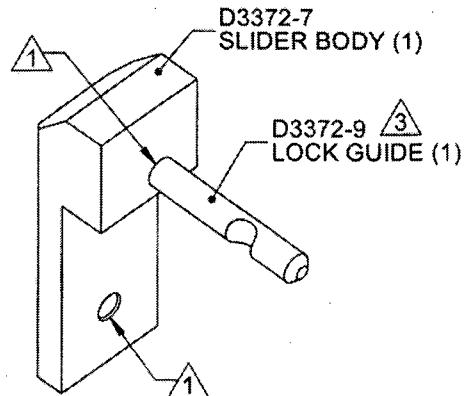
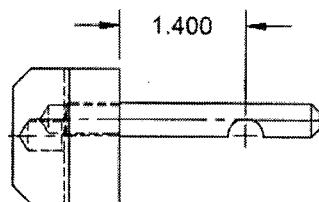
NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	D3372	REV. B SHEET 3 OF 8
DATE	05.02.23	TITLE	COLLECTIVE LOCK	SCALE 1:2

RELEASED
05/04/23

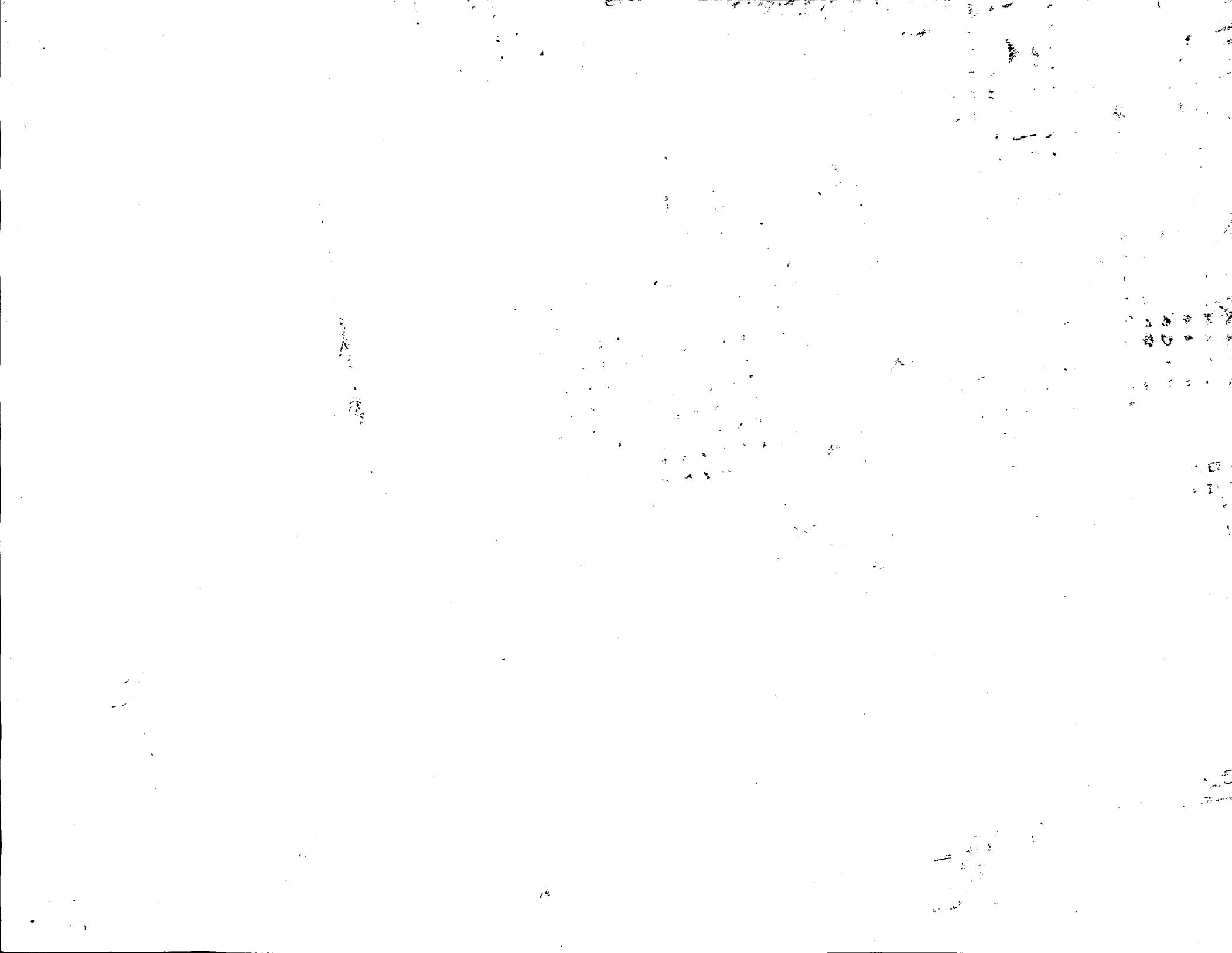


CL1107/18
WTO: 76036

D3372-055 SLIDER ASS'Y

NOTES:

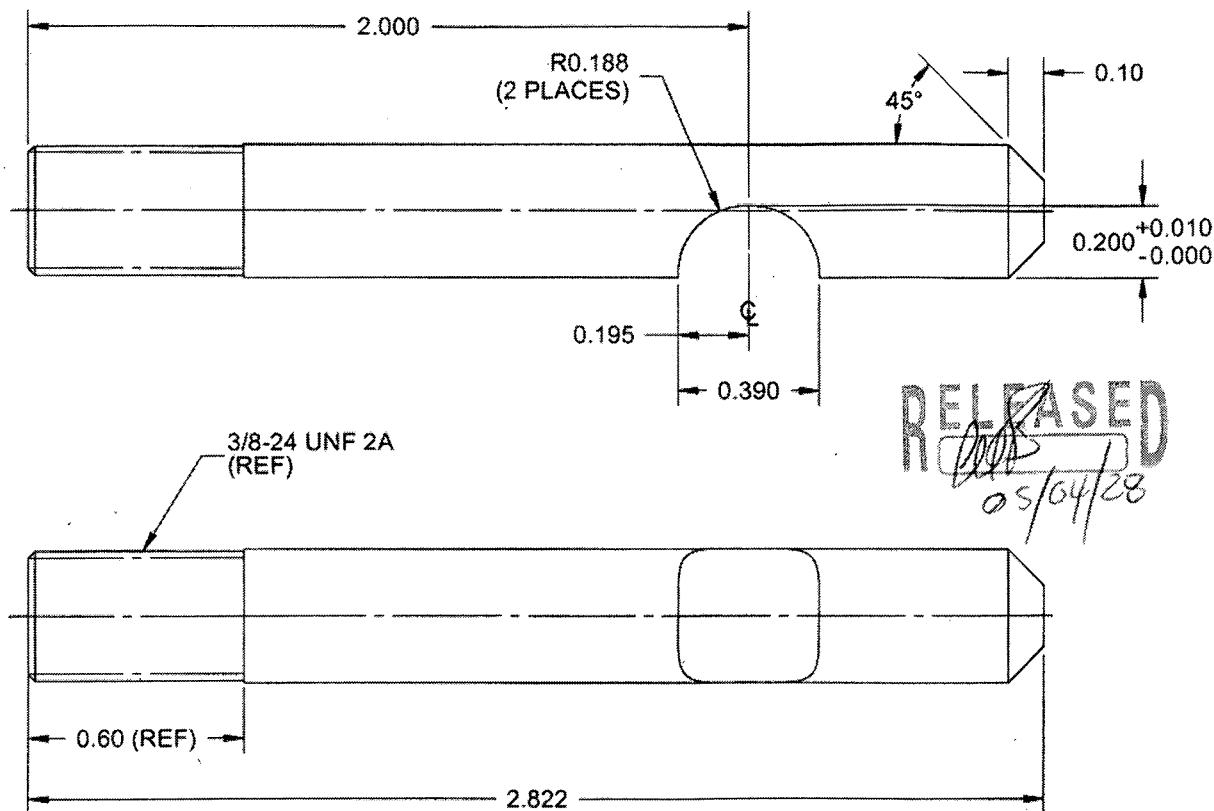
- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES



DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	D3372	REV. B SHEET 8 OF 8
DATE	05.02.23	TITLE	COLLECTIVE LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



cL11/07/18
W10.70036

D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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